

Tuesday, 4/17/2007 9 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job Number	: 31855	Part Number	: D3391021
Estimate Number	: 10467	Drawing Number	: D3391 REV.F
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: F
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Due Date	: 5/30/2007
Previous Run	: 31852	Qty:	1 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. A 05.09.13 New issue KJ/JLM		
	: Est. B 06.02.10 Dwg rev.D ecn 773 EC		
	: Est. C 06.05.02 Added inspections EC		
	: est D 07.03.13 rev F dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6013047	SKIDTUBE MAT'L
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	<i>B 26547</i>

119

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
Cut extrusion to 46.52 +0.010 -0.020

BE C7

3.0	BENDING	BENDING MACHINE
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Comment: No bender
Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-5-7

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-8

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine as per Folio FA590 Rev. *AA* & Dwg D3391 Rev. *F*
Identify as D3391-1

2-Deburr

07/05/15

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31853

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/05/15

(1)

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391

BC 07-05-22

(1)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 07-05-22

(1)

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/05/22

(1)

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr

7-5-23

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2005-25 11

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Jb 7-6-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31853

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07-07-14 (1)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m 104/144 *an-H* *BP 07-07-18*

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

U 27-24

16.0

NAS1330C3KB166

INSERT



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rivnut

Pick:

Qty

Part Number

Description

Batch

14

NAS1330C3KB166

Insert

M 102849 *16*

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

17 07-07-24 (1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1707/24 (1)

19.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

*B31346**17 07-07-24* (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31853

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE

B 31398

Y1

21.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET

B 32660

22.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN3C4A

Bolt

M 104955

Y1

23.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4

NAS1515H3L

Washer

M 104603

Y1

24.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

washer

M 105057

Y1

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install tow Cap as per Dwg D3391

Identify as D3391-021

Y1 07-07-24

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect thread of each insert using DT8824

inspect to current step

PFD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/07/24	26	Change to inspect to current step	En	07/07/24			En 07/07/24

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, 4/17/2007 11:10:09 AM

Kim Johnston

Process Sheet

Customer: EU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31853

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP

33528

6/7/30

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D. Johnston

Job Completion



U 8-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

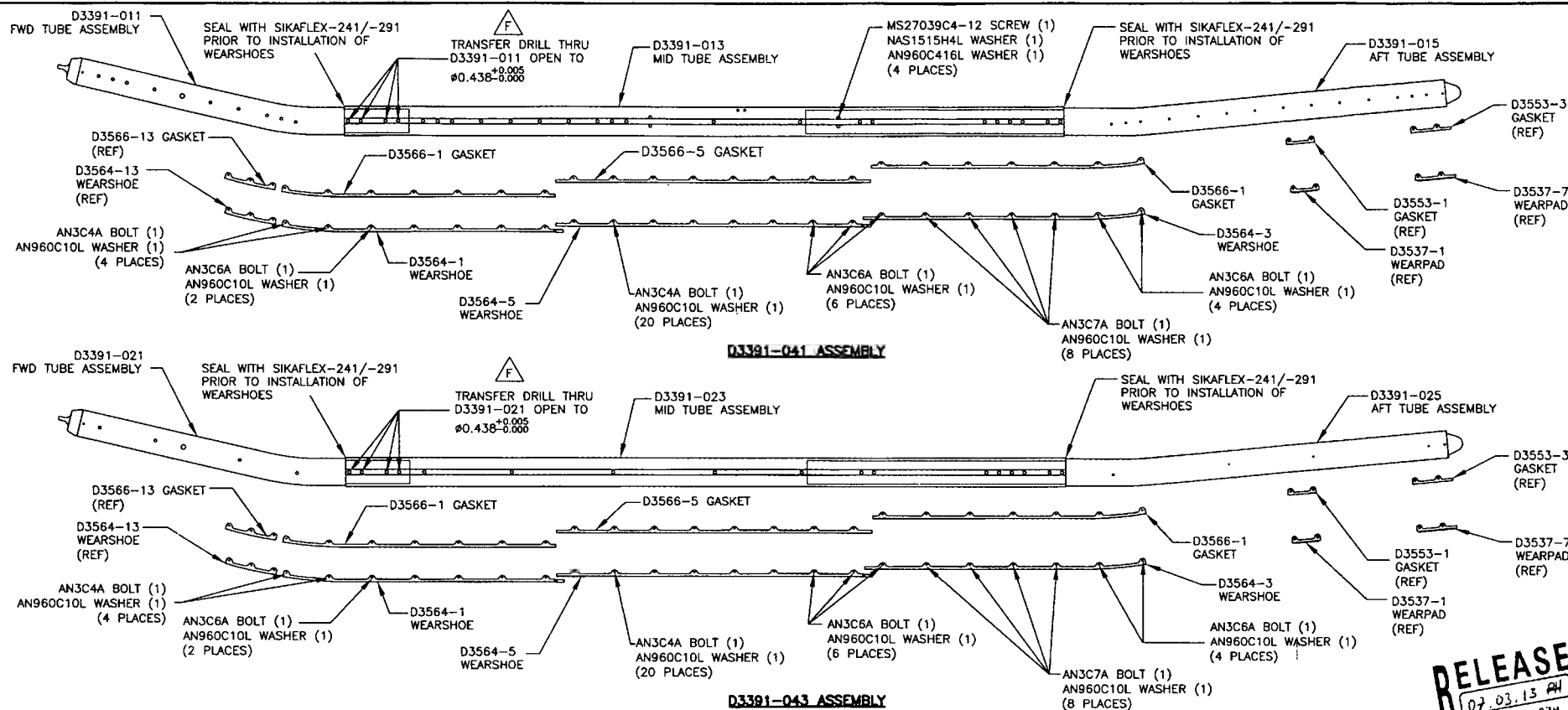
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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DTB217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.01.18	TITLE
		412 FLOAT SKIDTUBE
		SCALE
		NTS

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

DRAWING NO.
D3391

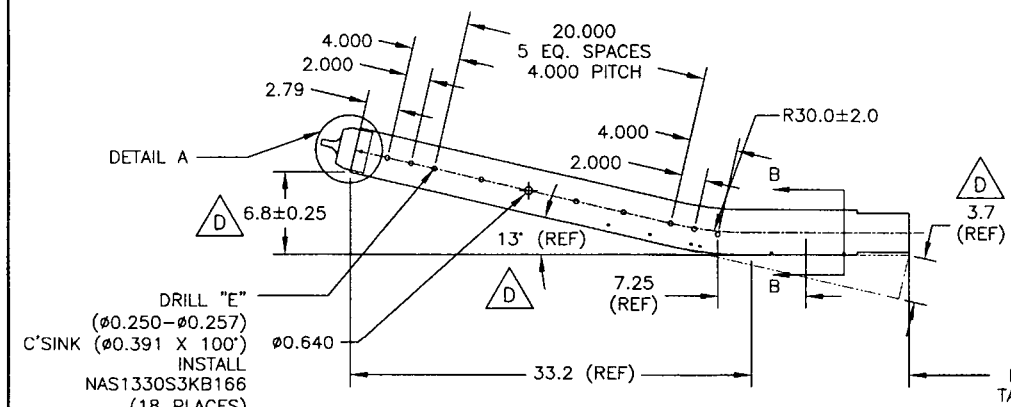
REV. F

SHEET 1 OF 5

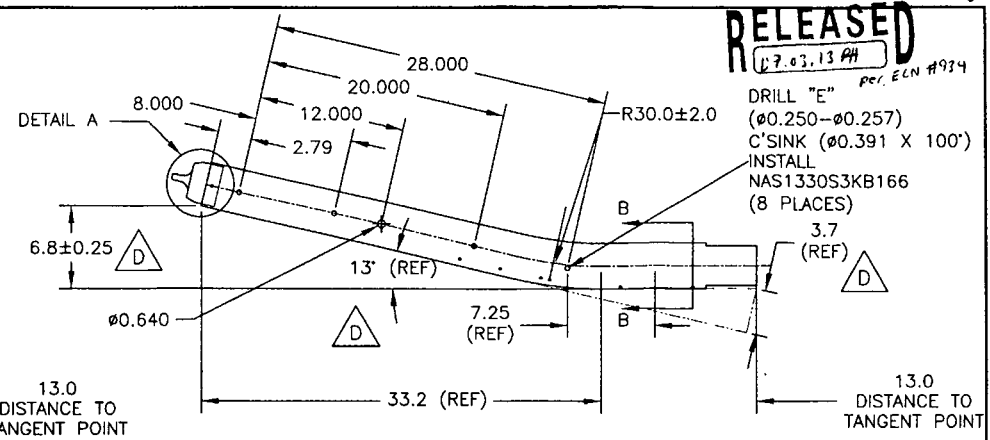
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NTS

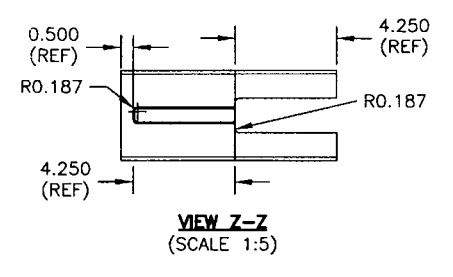
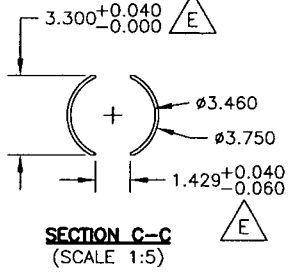
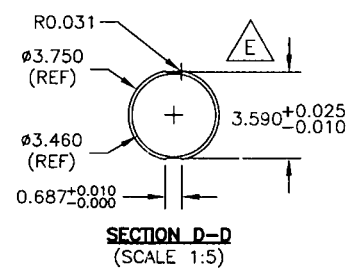
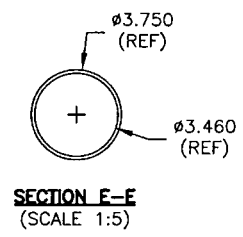
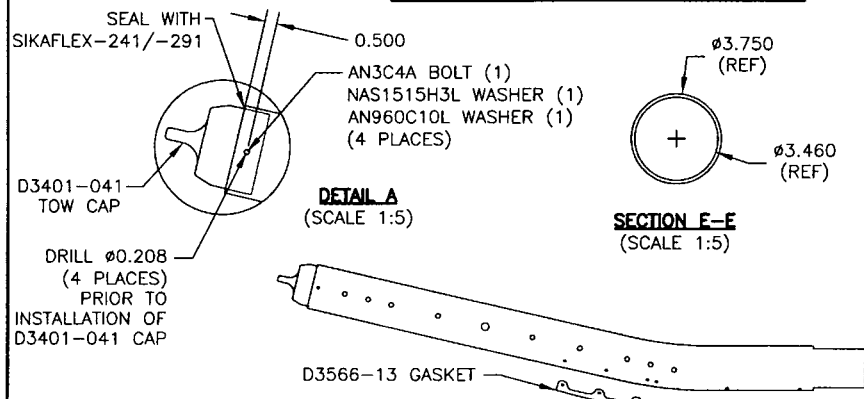
RELEASED
17.03.13 AH
Per ECN #934



D3391-011 ASSEMBLY AND BENDING DETAIL



D3391-021 ASSEMBLY AND BENDING DETAIL

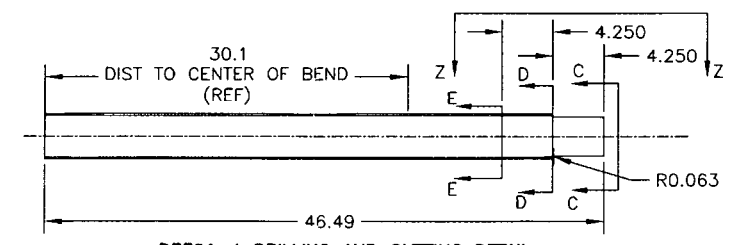
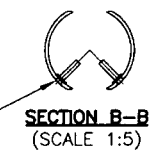


D3391-011/-021 WEARSHOE ASSEMBLY

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

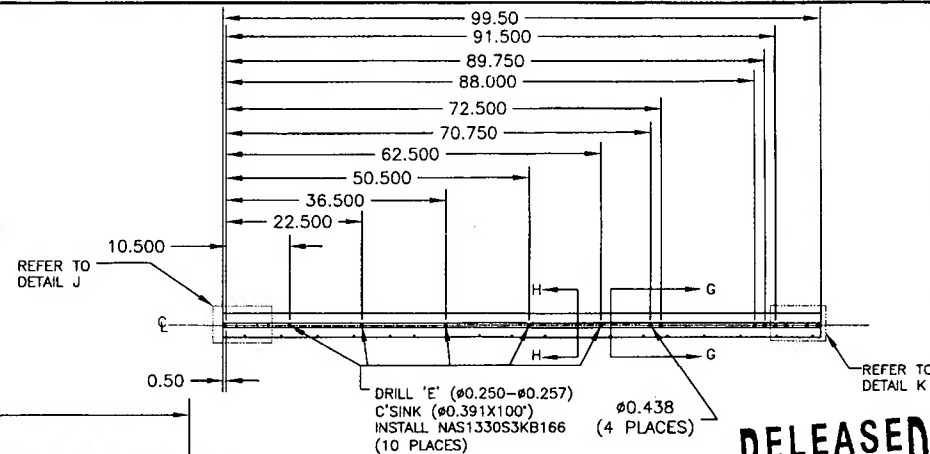
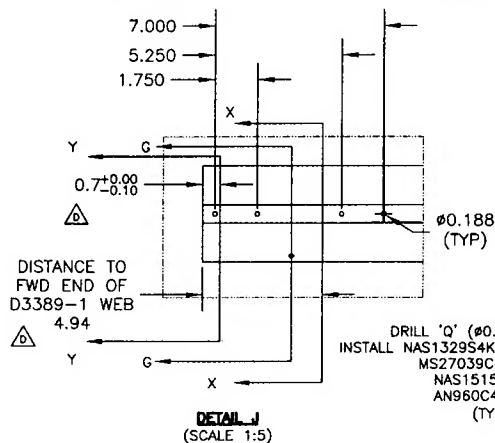
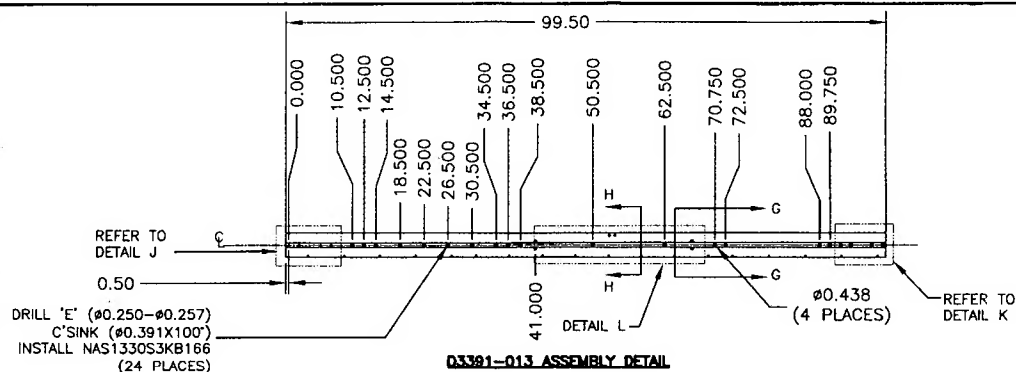
5
DRILL "E"
(Ø0.250-Ø0.257)
C'SINK (Ø0.391 X 100')
INSTALL
NAS1330S3KB166
(12 PLACES)



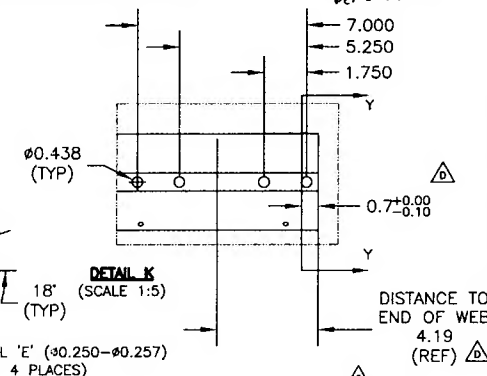
D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		REV. F SHEET 2 OF 5 SCALE 1:10

UNCONTROLLED COPY
SUBJECT TO AN INQUIRY
WITHOUT NOTICE
3/18/13



D3391-023 ASSEMBLY DETAIL



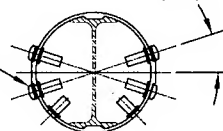
D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

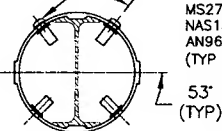
D3391-013/-023 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

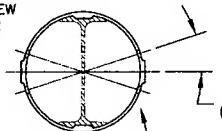
SECTION I-I
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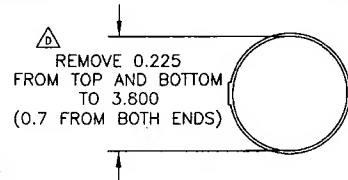
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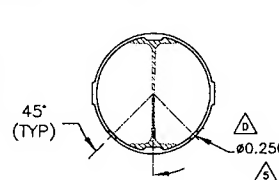
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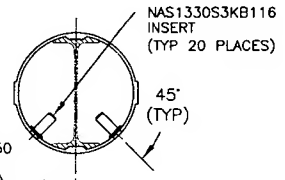
SECTION Y-Y
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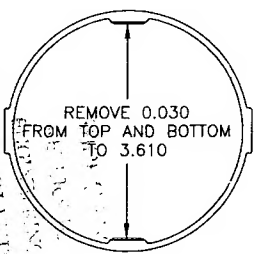
SECTION G-G
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)



SECTION X-X
(SCALE 1:2)

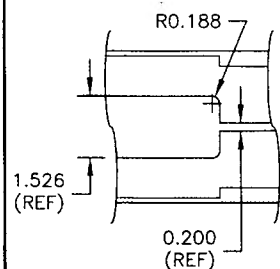


RELEASED
07.03.13 RH
DCI ELM #934

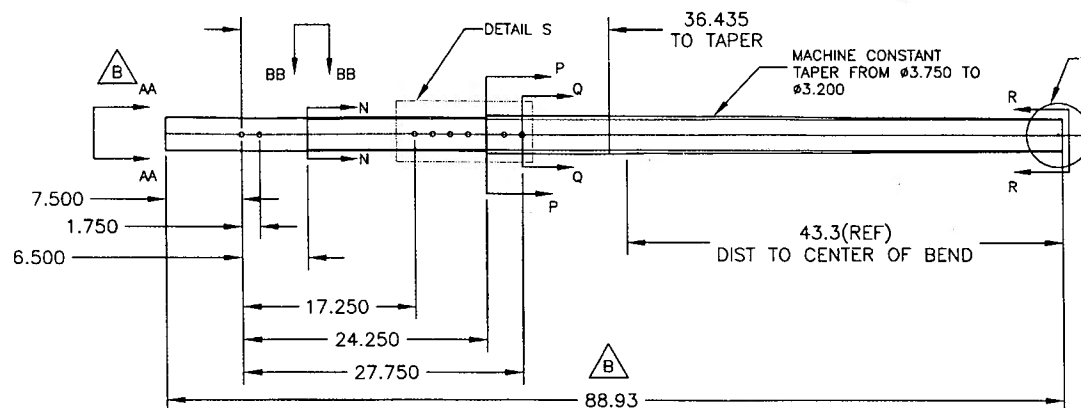
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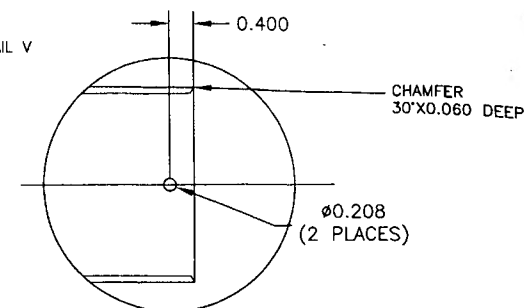
DESIGN RH	DRAWN BY RH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. F
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3391	SHEET 3 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:20	



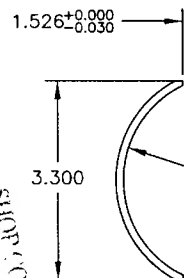
VIEW BB-BB
(SCALE 1:3)



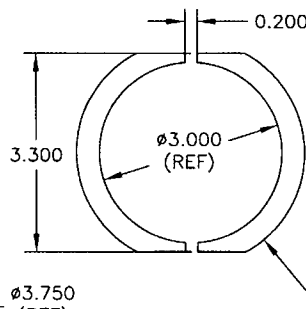
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



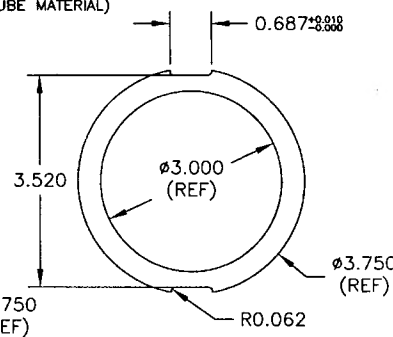
DETAIL V
(SCALE 1:2)



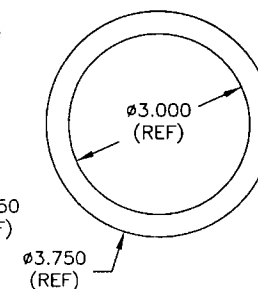
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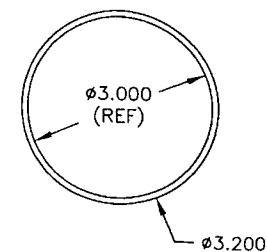
SECTION N-N
(SCALE 1:2)



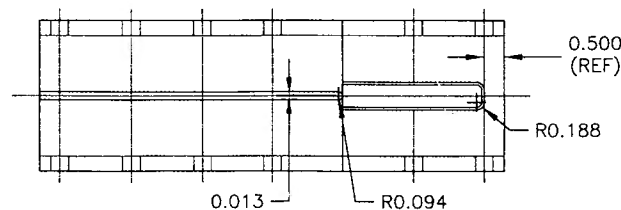
SECTION P-P
(SCALE 1:2)



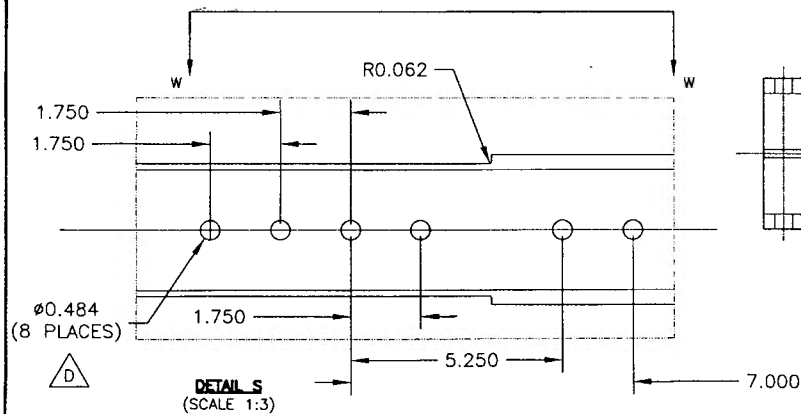
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



VIEW W-W
(SCALE 1:3)



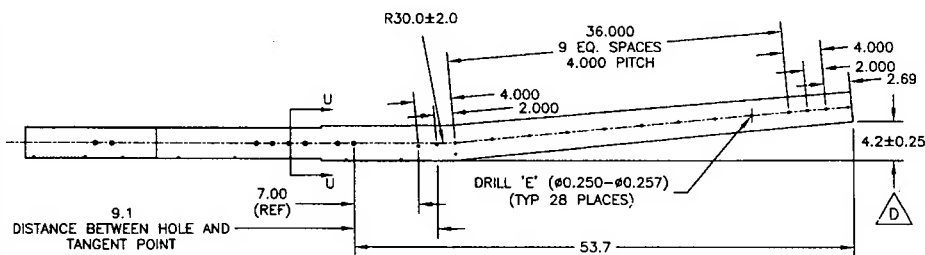
DETAIL S
(SCALE 1:3)

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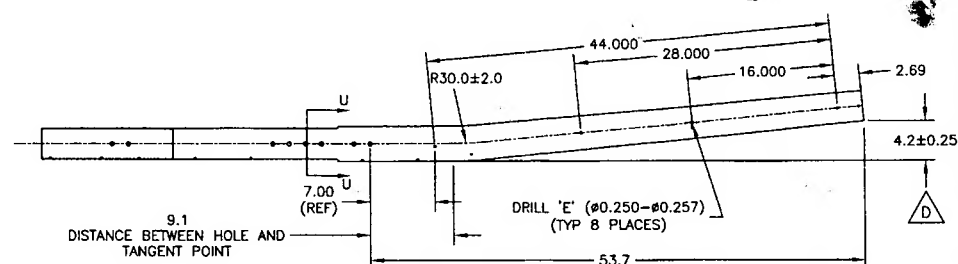
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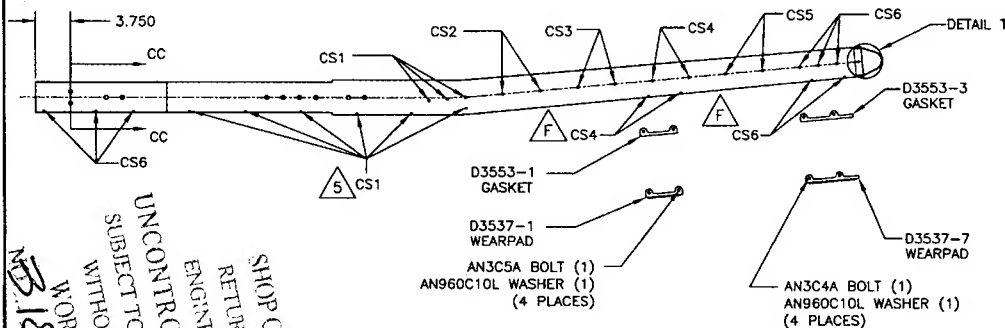
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. F
CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	



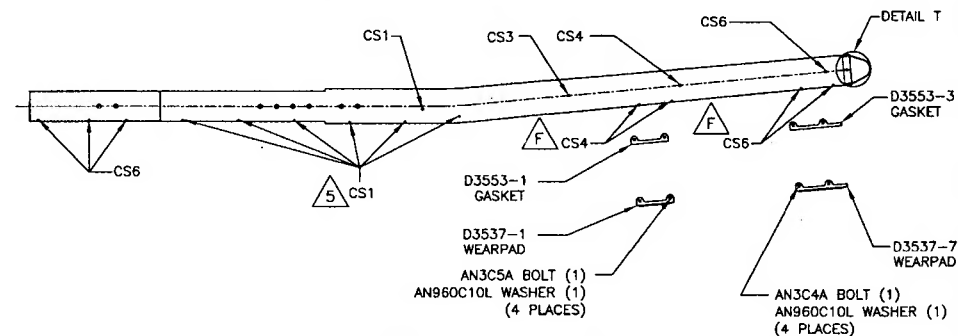
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



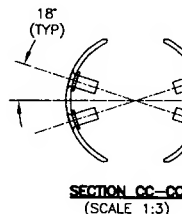
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



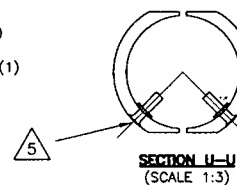
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100")
NAS1330S4KB151 INSERT (1)
(4 PLACES)



AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)
DETAIL T
(SCALE 1:3)
SEAL WITH
SIKAFLEX-241/-291

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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